

MAR 27 2018

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DART
AEROSPACE

D119-755-014
Job Sheet 171020



Part No: D119-755-014

Job Qty: 1 ea

Part Name: Bubble Window, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 2/20/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP A New Issue 6/28/2007 DL IPP B Dwg. Update 4/25/2008 DL verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/20/18	0.00	0.00	Start Up Stores/Pkg-1		MAR 27 2018
110	Packaging	1 pcs		2/20/18	0.00	0.00	Packaging1-1		
120	QC	1 pcs		2/20/18	0.00	0.00	QC4		PD 13-327
125	DC	1 pcs		2/20/18	0.00	0.00	DC		DAS 58
130	Packaging	1 pcs		2/20/18	0.00	0.00	Packaging3-1		58 DAS 9-89
140	QC21-FG	1 Ea		2/20/18	0.00	0.00	QC21		21 APR 26 2018

Part Op 125 - Photocopy bluefile & type labels per PPP 119-755-014 CHG 001

Descriptions: 130 - Identify and pack for shipping as per PPP D119-755-014 Location : FG104

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2126	Locking Seal (Sold Per Foot)	7.0833 ft (7.0833 ea)	90-Start up Operation	5024336
D3561-1	Seal Insert Tool	1 Ea (1 ea)	90-Start up Operation	7150421
D3624-2	Bubble Window	1 Ea (1 ea)	90-Start up Operation	5061364

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2126 - 0850 pieces	7 feet	459	0
	D3561-1	1	5	0
	D3624-2	1	0	0

Part Specifications

Specifications c

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S065143



Part: D119-755-014

Job No: 171020

Serial No/Batch: S065143

Revision:

Inspector:

Date: 04/25/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

3.2 Installation of D119-755-014 Bubble Window Kit

The Dart D119-755-014 Bubble Window Kit installs in the RH crew door of the A119/AW119MKII aircraft and should be installed as follows:

- 3.2.1 Remove RH crew door (109-0360-01-164 or equivalent) from the aircraft per the Aircraft Maintenance Manual.
- 3.2.2 Remove the existing window per the Aircraft Maintenance Manual or applicable instructions.
- 3.2.3 Install the D3624-2 Bubble Window in the doorframe using D2126-0850 Seal as shown in Figure 1. Before actually installing the window, verify that there is at least 0.30" (7.6mm) of overlap between the window and the door frame along the straight edges of the window and at least 0.12" (3.0mm) of overlap along the radius of the corners. The recommended procedure is to install the seal onto the door and then to install the window into the seal. Trim the ends of the seal as required. Seal ends should meet at the 6 o'clock position with a maximum gap of 0.125" (3.2mm). If a gap exists, it should be filled with Proseal or PRC. The included D3561-1 Seal Insert Tool can be used to assist in working the seal around the window. If necessary, it is acceptable to trim the window to improve the fit as long as the minimum overlap values are maintained.
- 3.2.4 Reinstall modified crew door on the aircraft per the Aircraft Maintenance Manual. Verify proper closing and sealing of the door.
- 3.2.5 Note: To increase downward viewing clarity, it is acceptable to cut a small section from the bubble window on its downward side. The cut-out can be a maximum of 5.25" wide x 13.50" long (133mm x 343mm), measured along the profile of the bubble window. The corners of the cut-out must have a minimum radius of 2" (50mm). The cut-out should be located within 1.0" to 1.5" (25mm to 38mm) of the bubble flange. The actual shape of the cutout can vary as desired, as long as the overall dimensions are within the specified limits. See Figure 2 for reference.

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-755-011 Crew Door Window Kit, LH / RH	3.5 lb 1.6 kg	±27.6 in ±0.70 m	±97 in-lb ±1.12 m-kG	63 in 1.60 m	220 in-lb 2.6 m-kG
D119-755-014 Bubble Window Kit, RH	4.5 lb 2.0 kg	+31.6 in +0.80 m	+142 in-lb +1.60 m-kG	63 in 1.60 m	284 in-lb 2.6 m-kG

5.0 PARTS LIST

Qty -011	Qty -014	Part Number	Description
X		D119-755-011	CREW DOOR WINDOW KIT (FITS LH & RH)
	X	D119-755-014	BUBBLE WINDOW KIT, RH
1	1	D2126-0850	SEAL
1		D3623-1	WINDOW
	1	D3624-2	BUBBLE WINDOW
1	1	*D3561-1	SEAL INSERT TOOL

* Not part of the -011/-014 installations, tool only

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